

Work Order ID 65462

January 18, 2011 10:30:01 AM



Page 1

Item ID: D3996-FE-832-EF

Accept



Setup Start



Revision ID:

Stop



Item Name: Self-Clinching Fastener

Start Date: 1/18/11 Start Qty: 100.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 1/10/18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3996

A

0.00



Purchasing

Memo

0.00

Issue P/O: 133# 13269

Purchase Part Number: FE-832-EF

Supplier: Interfast Inc.

Certificate of conformity is required

CL 1/10/18 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

CL 1/10/18 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65462

January 18, 2011 10:30:01 AM



Page 2

Item ID: D3996-FE-832-EF

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Su 1/21/11

QSP019

X100

(cont'd)

130

Identify as per dwg & Stock Location: 103

0.00



Packaging

Memo

0.00

Packaging

11/2/8

1000

S

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/14

MF

11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2011 10:30:00 AM

Page 1

Work Order ID: 65462



Parent Item: D3996-FE-832-EF



Parent Item Name: Self-Clinching Fastener



Start Date: 1/18/11

Required Date: 1/21/11

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF  PEM Insert		Purchased	No			110	Each	0.0000	1 	100 <u>CL 11/02/08</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

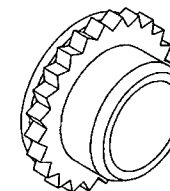
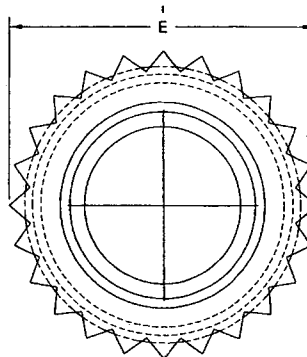
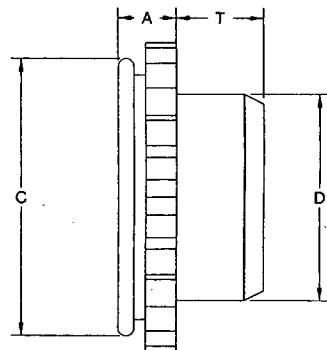
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C +0.000 -0.005	D MAX	E ±0.005	T +0.015 -0.000	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST: HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

NOTES

1) SPECIFICATION: PENNENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE
"YYY" = THREAD CODE PER TABLE
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:
DART P/N = D3996-FE-832-EF
PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II
"CI" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III
"EF" = ELECTRO-FILM PER MIL-PRF-46010
"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65462
CL1110118

RELEASED
2009-11-08

A	NEW ISSUE	CP	09.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3996
REV. A
SHEET 1 OF 1

TITLE SELF-CLINCHING FASTENER
SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577

OUTSTANDING PO REPRINT

Purchase Order ID PO13269

Purchase Order Date 1/13/2011

PO Print Date 2/4/2011

Page Number 1 of 2

Order From :
INTERFAST INC.
22 WORCESTER ROAD
TORONTO, ON M9W 5X2
CA

VC-INT001

Contact Name	Buyer	Chantal Lavoie
Vendor Phone 613 596 2663	Requisition Nbr	
Vendor Fax 613 596 2779	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
Ship To :	DART AEROSPACE LTD	1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA				

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	MS21920-20	Clamp (per MIL-DTL-8783C)	2/4/2011 Yes	50.00 Each	FedEx PI ppd	\$14.9500	\$747.50
Line Total:							\$747.50
2	2600-6	Camlock Stud	2/4/2011 Yes	100.00 Each	FedEx PI ppd	\$2.9500	\$295.00
Line Total:							\$295.00

REFERENCE ONLY

2/4/2/3

PO Instructions: PLEASE SHIP FEDEX P1 ACCT: 15179234-0

2/3/2011

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577

OUTSTANDING PO REPRINT

Purchase Order ID PO13269

Purchase Order Date 1/13/2011

PO Print Date 2/4/2011

Page Number 2 of 2

Order From :

VC-INT001

INTERFAST INC.
22 WORCESTER ROAD
TORONTO, ON M9W 5X2
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 596 2663	Requisition Nbr	
Vendor Fax	613 596 2779	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
3 381	2600-LW	Camloc Retaining Washer	2/4/2011 Yes	✓ 50.00 Each	FedEx PI ppd \$0.2500	\$12.50
Line Total:						\$12.50
4 381	212-12	Receptacles	2/4/2011 Yes	✓ 100.00 Each	FedEx PI ppd \$2.2500	\$225.00
Line Total:						\$225.00
5 285	FE-832-EF	PEM Insert	2/4/2011 Yes	✓ 100.00 Each	FedEx PI ppd \$0.3000	\$30.00
Line Total:						\$30.00
Special Inst: AS PER DWG D3996 REV. A B65462						
Outstanding PO Total:						\$1,310.00

REFERENCE ONLY

PO Instructions:

PLEASE SHIP FEDEX PI ACCT: 15179234-0

Change Nbr: 5

Change Date: 2/3/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



22 WORCESTER ROAD, TORONTO, ON, CAN, M9W 5X2
TEL: 1-416-674-0770 FAX: 1-416-674-5804
WEBSITE: www.interfast.ca

Packing Slip

PACK-SLIP REV: NC DATE: 09/30/03



Invoice#:

561082

02-FEB-11

SV DART AEROSPACE LIMITED
OE 1270 ABERDEEN ST.
LN HAWKESBURY ON
DD K6A 1K7
U CAN
T
OA

SE DART AEROSPACE LIMITED
HX 1270 ABERDEEN ST.
IP HAWKESBURY ON
PE CAN K6A 1K7
D
T
O
R

SHIP MODE: Fedex Domestic Within Canada
MODE D'EXPEDITION:

FOB: FOB - Interfast Dock
F.A.B.:

NO. CARTONS: 1

WAYBILL #: 943828262326
FACTURE DE VOIE #:

CUSTOMER PO#:
N° DU BON DE COMMANDE:



PO13269

CUSTOMER #:
CLIENT #:

110900

OUR SALE #:
N° DE LA VENTE:

493140

TERMS: Net 30 Days (01)
MODALITES:

QUANTITY ORDERED QUANTITE COMMANDEE	U/M M.N.R.	QUANTITY SHIPPED QUANTITE EXPEDIEE	BALANCE DUE SOLDE	PART# & DESCRIPTION PARTIE # ET DESCRIPTION	LOT# / Serial#
50.00	EA	50.00	0.00	Cust PO Line#: Cust Part#: MS21920-20 Boeing Cert Or Mcc Mfr Certificate Of Conformance With Lot Traceability Part#: MS21920-20 Decription: CLAMP Packbox#: PACK485112 Lot Line#: 1 Qty: 50 Mfr: VOSS INDUSTRIES, INC. Expire Date Country Of Origin: USA	152390
50.00	EA	50.00	0.00	Cust PO Line#: Cust Part#: 2600-LW Boeing Cert Or Mcc Chemical Test Reports Mfr Certificate Of Conformance With Lot Traceability Physical Test Reports Part#: BACW10X4 Decription: WASHER Packbox#: PACK485112 Lot Line#: 2 Qty: 50 Mfr: MONADNOCK COMPANY Expire Date Country Of Origin: USA	M536510

Call 1/2/3



Packing Slip



Invoice#: 561082

QUANTITY ORDERED QUANTITÉ COMMANDEE	U/M M.N.R.	QUANTITY SHIPPED QUANTITÉ EXPÉDIÉE	BALANCE DUE SOLDE	PART# & DESCRIPTION PARTIE # ET DESCRIPTION	LOT# / Serial#
100.00	EA	100.00	0.00	Cust PO Line#: Cust Part#: 212-12 Boeing Cert Or Mcc Chemical Test Reports Mfr Certificate Of Conformance With Lot Traceability Physical Test Reports Part#: BACR11AW2 Decription: RECEPTACLE Packbox#: PACK485112 Lot Line#: 3 Qty: 100 Mfr: MONADNOCK COMPANY Expire Date Country Of Origin: USA	544765
100.00	EA	100.00	0.00	Cust PO Line#: Cust Part#: FE-832-EF Part#: FE-832-EF Decription: NUT ** Packbox#: PACK485112 Lot Line#: 4 Qty: 100 Expire Date Country Of Origin: USA	D580370001

Silco2/00

4/12/3

Total Qty Shipped: 300

GST/TPS # R102504958 QPST/TVQ #1009982431TQ0001

PAST DUE ACCOUNTS WILL BE SUBJECT TO A SERVICE CHARGE OF 1.5% PER MONTH. INTERFAST WILL BE RESPONSIBLE FOR THE AUTHORIZED REPLACEMENT OF GOODS WHICH ARE DEFECTIVE OR WHICH ARE NOT TO SPECIFICATION PROVIDED THAT CLAIMS ARE MADE WITHIN 14 DAYS OF SHIPMENT.

LES COMPTES EN SOUFFRANCE SERONT ASSUJETTIS À DES FRAIS DE SERVICE DE 1.5% PAR MOIS. INTERFAST NE SERA RESPONSABLE QUE POUR L'ÉCHANGE AUTORISÉ DE BIENS DÉFECTUEUX OU QUI NE SONT PAS CONFORMES AUX SPÉCIFICATIONS À CONDITION QUE LES RÉCLAMATIONS SOIENT EFFECTUÉES DANS LES QUATORZE (14) JOURS SUIVANT L'EXPÉDITION.

"I hereby certify that the items, or materials covered by this document have been inspected and tested and conform to all applicable specifications relative thereto, and unless authorized by customers, no work or alterations have been performed. Supportive documentary evidence of conformance is either on file or available upon request.."

"Je certifie par les présentes que les articles ou matériaux couverts par le présent document ont été inspectés et testés, et qu'ils sont conformes à toutes les spécifications applicables en ce qui a trait auxdits articles ou matériaux. À moins d'avoir obtenu l'autorisation du client, aucun remaniement ni aucune modification n'ont été apportés. La documentation de soutien prouvant la conformité se trouve dans le dossier ou est disponible sur demande."

Dave Dawkins

Dave Dawkins
Manager Of Quality

